

Date: Thursday, 5/3/2007 11:38:03 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET ASS'Y
Job Number	: 32195		
Estimate Number	: 12525		
P.O. Number	: N/A	Part Number	: D3531041
This Issue	: 5/3/2007 S.O. No. : <i>N/A</i>	Drawing Number	: UNDER REVIEW <i>CB</i>
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i>	Drawing Revision	: N/A
Previous Run	: 31170	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 5/28/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	3 Um: Each
Comment	: Est Rev: A New Issue 06-09-08 EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	D35311	BRACKET
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\* Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)  
 BRACKET *B32207* x3 *\*\*\* on stock*

2.0	D35313	BRACKET FRONT PLATE
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)  
 BRACKET FRONT PLATE *B32208* x3 ✓

3.0	MS20470AD44	Rivet, Universal Head
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Comment: Qty.: 12.0000 Each(s)/Unit Total: 36.0000 Each(s)  
 Rivet, Universal Head *M104214* ✓ *ml07/05/29*

4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
 Assemble as per dwg D3531

*ml07/05/29*

5.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

*2005.25 (3)*

6.0	POWDER COATING	POWDER COATING
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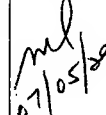

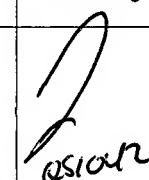
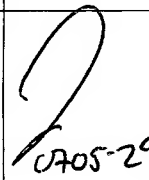


Comment: POWDER COATING  
 Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

*BR/am* *07/05/30.* *(3)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/06/09  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/05/09	4	Make the hole bigger when took out on rivet R.C. Human Error, hole was drilled off the center of the rivet, ovalizing the hole		Use 5/16 size for one hole Use rivet MS 20426 ADS-6 M2421 send out to L ADS-4 <del>MS 20426</del> Acceptable	 07/05/09	 ADS-29	 ADS-29	 0705-29

NOTE: Date & initial all entries

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Drawing Name: BRACKET ASS'Y

Job Number: 32195

Part Number: D3531041

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



7/5/31 SQ



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: SK222

7/5/31

SQ

(3)

LU

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

7/5/31

Job Completion



LU OFCOS B1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

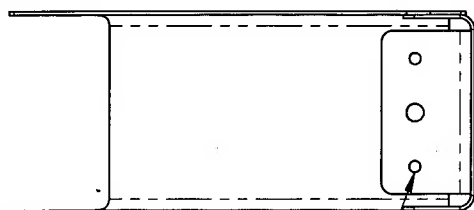
PRELIMINARY ISSUE

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED	DRAWING NO. D3531	REV. A SHEET 1 OF 3
DATE 07.01.10	TITLE BRACKET ASSEMBLY		SCALE 1:2
REV A	DATE 07.01.10	DESCRIPTION NEW ISSUE	

UNDER REVIEW

07.01.10 CB

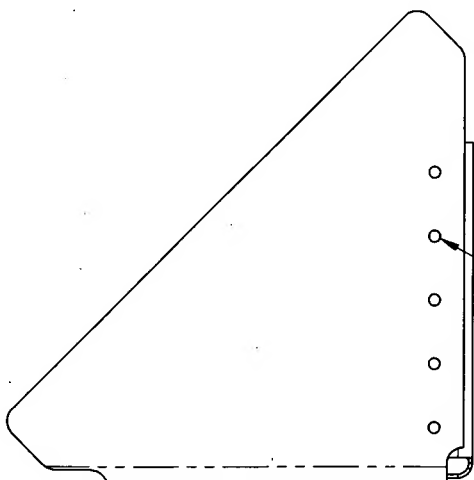
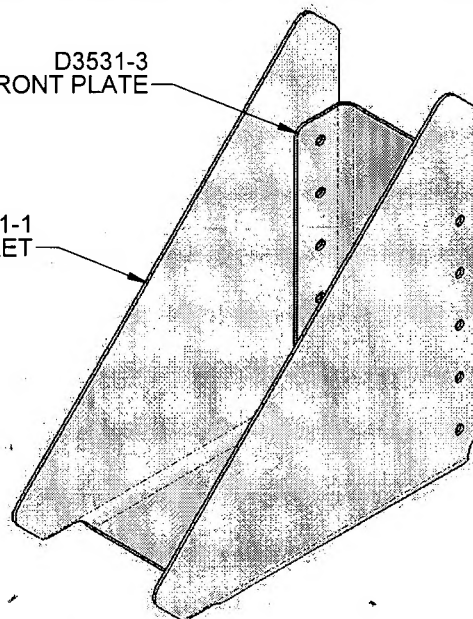
Draw not released



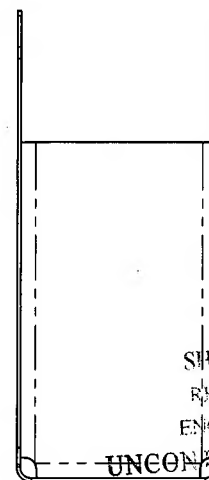
TRANSFER DRILL HOLES  
FROM D3531-1 THROUGH D3531-3  
BEFORE FINISH  
(3 PLACES)

D3531-3  
BRACKET FRONT PLATE

D3531-1  
BRACKET



MS20470AD4-4  
(12 PLACES)



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ENGINEERING

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 32195

### D3531-041 BRACKET ASSEMBLY

#### NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY BLACK  
SANDTEX (4.3.5.7) PER DART QSI 005 4.3  
ALL PARTS
- 2) ASSEMBLE PER DART QSI 003
- 3) IDENTIFY WITH DART P/N "D3531-041" USING  
WHITE MARKER

#### PARTS LIST

QTY.	P/N	DESCRIPTION
X	D3531-041	BRACKET ASSEMBLY
1	D3531-1	BRACKET
1	D3531-3	BRACKET FRONT PLATE
12	MS20470AD4-4	RIVETS

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